

Work Order ID 53896

November 23, 2009 11:26:23 AM

Page 1

Item ID: D3815-2

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 23/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 23/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals:

Process Plan: *PL*

Date: *12/1/23*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3815

Rev A

100

0.00



FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3815 ☐ Dwg Rev: *A* ☐ Prog Rev: *A*

☐

****grain direction along 4.30" ****☐2-Deburr if necessary

18 9-12-9

(10)

110

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

189-12-9

120

0.00



QC8- Inspect parts - second check

QC

Memo

0.00

Quality Control

=> 8 02/12/11

(Y80)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53896

November 23, 2009 11:26:23 AM

Page 2

Item ID: D3815-2

Accept

Revision ID: A

Item Name: Angle

Start Date: 23/11/2009 Start Qty: 8.00

Required Date: 27/11/2009 Req'd Qty: 8.00

Reference:

Cust Item ID:




Customer:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start

Stop

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130  Brake NC Brake NC	NC BRAKE Memo 1- deburr if necessary D3815	0.00 0.00				10			
			2- Bend as per Dwg SA 09/12/15						
140  QC Quality Control	QC5- Inspect part completeness to step on W/O Memo	0.00 0.00				10			
			27 8 02/12/15						
150  HandFinish Hand Finishing	Chemical Conversion Coat per QSI005 4.1 Memo	0.00 0.00				10			
			WMO 09/12/16						

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 53896

November 23, 2009 11:26:23 AM



Page 3

Item ID: D3815-2

Accept



Setup Start



Revision ID: A

Stop



Item Name: Angle

Start Date: 23/11/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 27/11/2009 Req'd Qty: 8.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

160

QC3- Inspect Part Finish

0.00



09/12/16

10

6

QC

Memo

0.00

Quality Control

170

Identify as per dwg & Stock Location: GA

0.00



09/12

10

6

Packaging

Memo

0.00

Packaging

180

QC21- Final Inspection - Work Order Release

0.00



09/12/22

QC

Memo

0.00

Quality Control

C 209/12/21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

November 23, 2009 11:26:29 AM

Page 1

Work Order ID: 53896



Parent Item: D3815-2RevA



Parent Item Name: Angle

Start Date: 23/11/2009

Required Date: 27/11/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
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M2024T3S.063

Purchased

No

100

sf

36.4396

3.8973



2024-T3 .063 sheet

18 9-12-4

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

MAT

36.43962419

102942

1.5

105916

1.09

106223

1.47

109463

0.00947368

110980

5.4854

111787

24.8847505

19059

2

11787

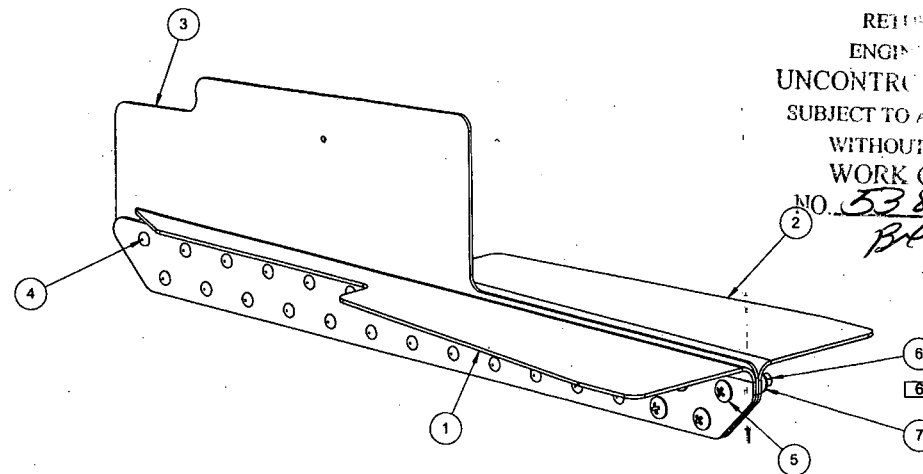
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK C
NO. 53896
B-008-11-23

ITEM NO.	PART NUMBER	DESCRIPTION	QTY. .041
1	D3815-1	ANGLE	1
2	D3815-2	ANGLE	1
3	D3815-3	WEB	1
4	MS20470AD4-6	RIVET	25
5	AN526C832R14	SCREW	4
6	MS21042L08	NUT	4
7	NAS1149DN832J	WASHER	4

D3815-041 WEB ASSEMBLY

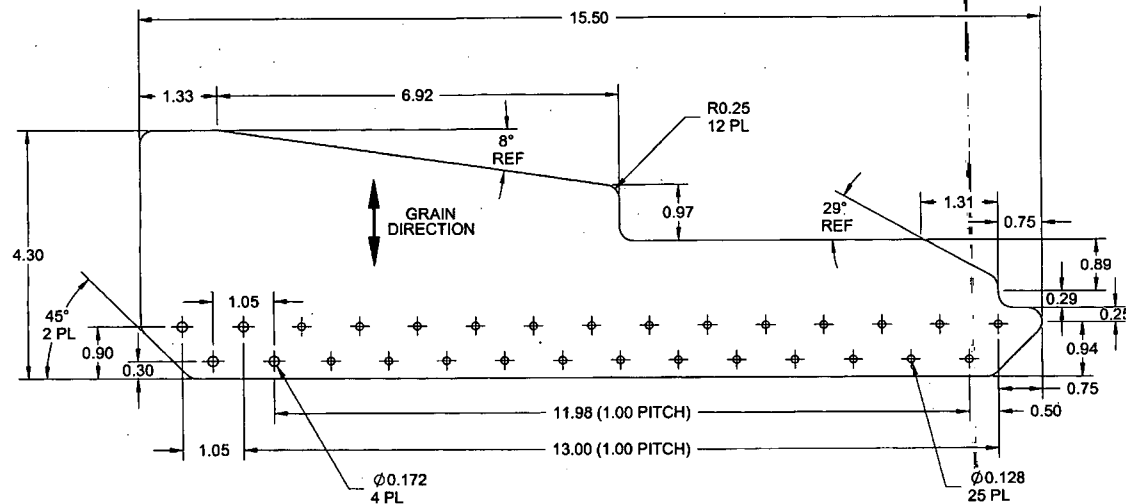
RELEASED
09/03/10

NOTES:

- 1) FINISH: POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
- 2) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) UNITS: INCHES UNLESS OTHERWISE NOTED
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-041 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.88 lbs
- 6) INSTALL LOOSE (4 PLACES) AFTER POWDER COAT

A	NEW ISSUE	08.09.22
REV.	DESCRIPTION	BY DATE
DESIGN	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA DRAWING NO. D3815 TITLE WEB SCALE NTS	REV. A
DRAWN		SHEET 1 OF 5
CHECKED		
MFG. APPR.		
APPROVED		
DE APPR.		
DATE	08.09.22	

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D3815-1F FLAT PATTERN

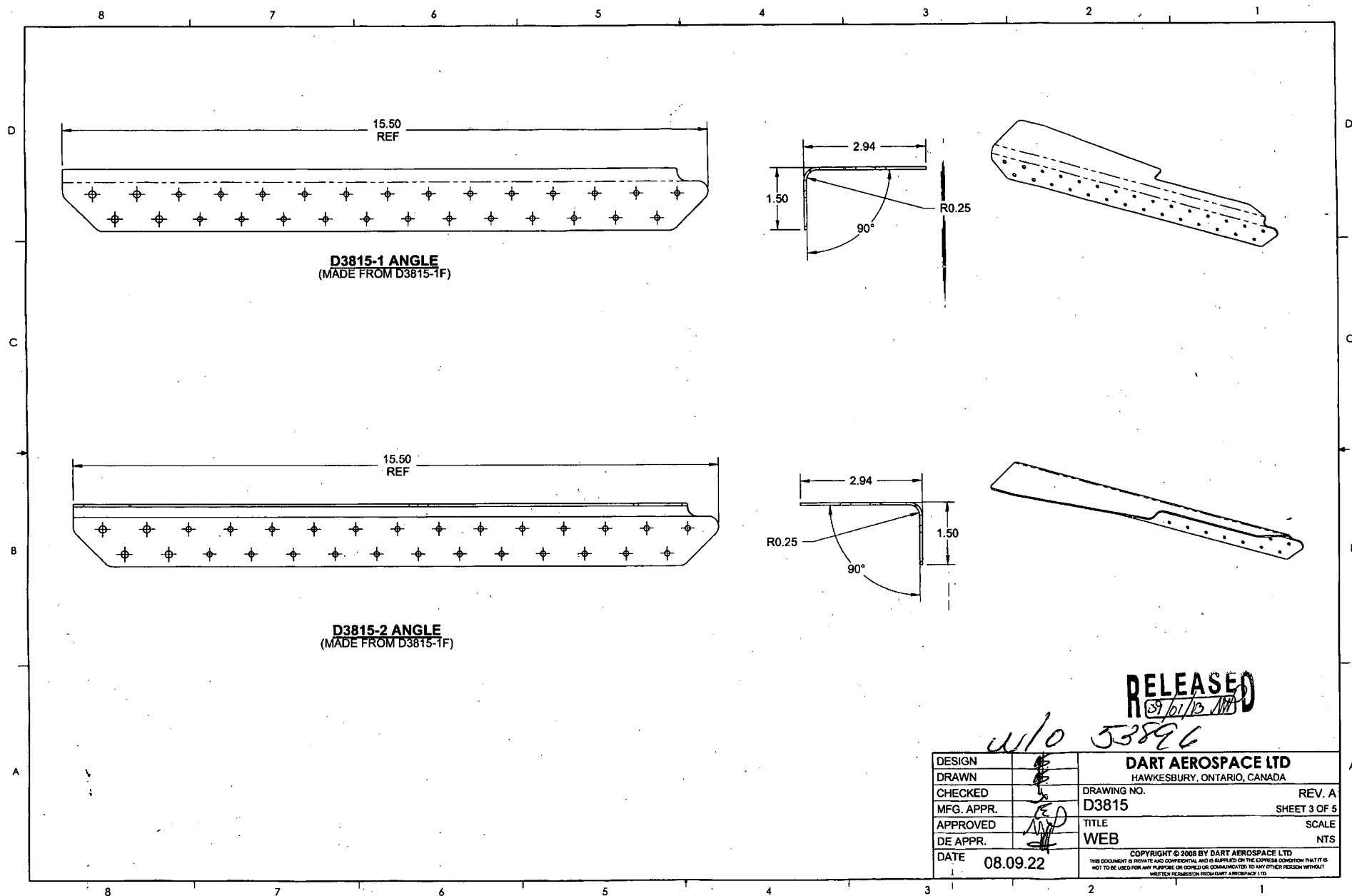
RELEASED
07/01/13

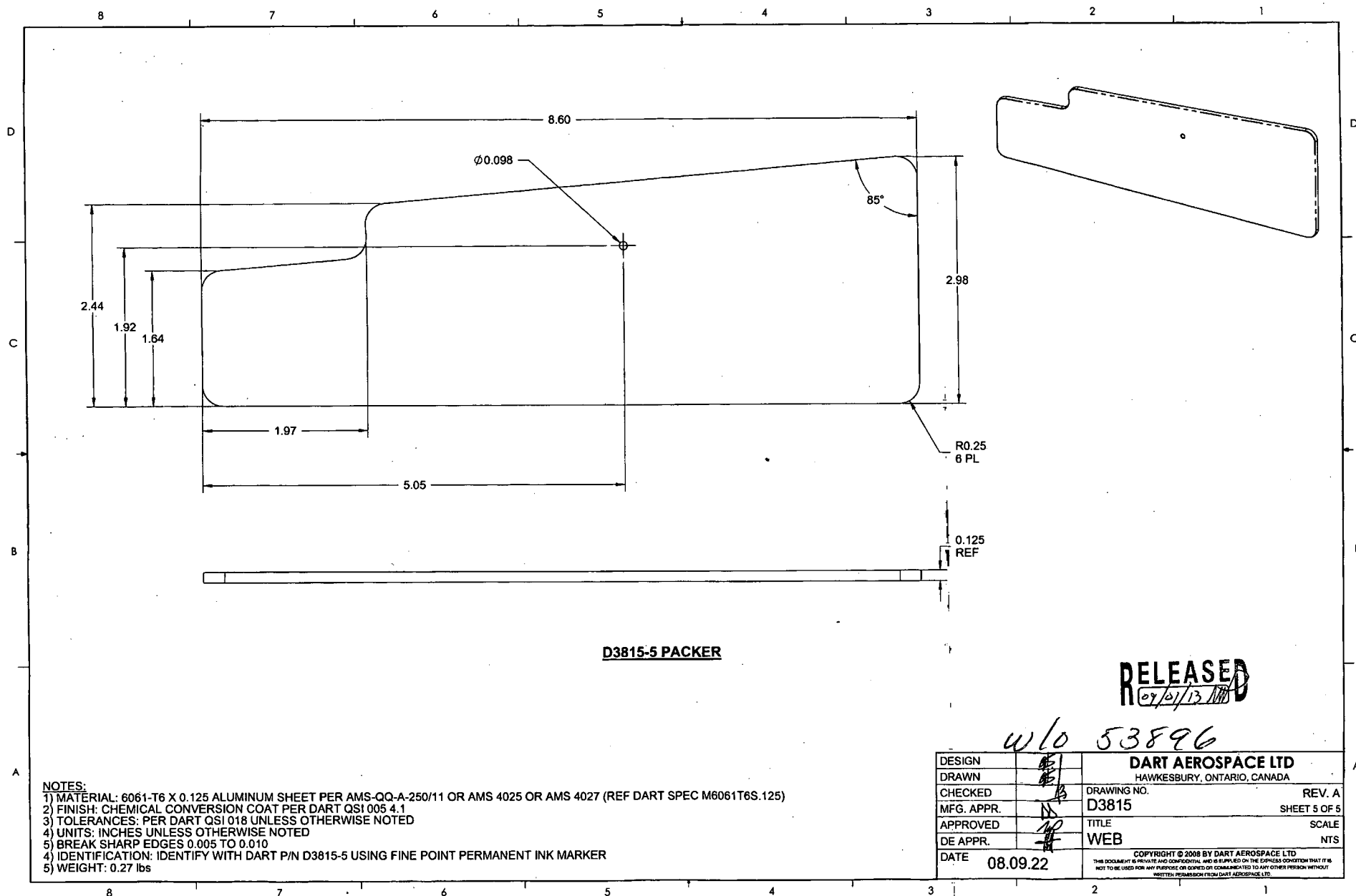
W10 53894

NOTES:

- 1) MATERIAL: 2024-T3 X 0.063 ALUMINUM SHEET PER AMS-QQ-A-250/4 OR AMS 4037 (REF DART SPEC M2024T3S.063)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.29 lbs

DESIGN		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA		
DRAWN				
CHECKED			DRAWING NO.	REV. A
MFG. APPR.			D3815	SHEET 2 OF 5
APPROVED			TITLE	SCALE
DE APPR.			WEB	NTS
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NOTES:

- 1) MATERIAL: 6061-T6 X 0.125 ALUMINUM SHEET PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 (REF DART SPEC M6061T6S.125)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES 0.005 TO 0.010
- 4) IDENTIFICATION: IDENTIFY WITH DART P/N D3815-5 USING FINE POINT PERMANENT INK MARKER
- 5) WEIGHT: 0.27 lbs